



Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5553-1

Job Sheet 183905



Part No: D5553-1

Job Qty: 10 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5553 REV.A IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS PER DWG
REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Machining-4		mmc 18/10/20
100	Bandsaw	10 pcs	10/5/18	10/5/18	0.00	0.00	Bandsaw1		"
110	CNC Vertical Machining	10 pcs	10/5/18	10/5/18	0.00	16.35	HAAS1-1		"
120	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Machining-4		"
130	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-4		A.E 18-10-20
135	Outsource	10 pcs	10/5/18	10/5/18			GRO002-VC	5	
140	Packaging	10 pcs	10/5/18	10/5/18	0.00	0.00	Packaging2		NOV 05 2018
160	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC5		
170	Packaging	10 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		NOV 08 2018
180	QC21-SA	10 Ea	10/5/18	10/5/18	0.00	0.00	QC21		21 NOV 08 2018

Part Op 100 - Cut blank: 5.75" LONG

Descriptions: 110 - 1- Machine as per Folio FB564 and Dwg D5553 DWG REV: FOLIO REV: Deburr

135 - ISSUE P/O: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 C
OF C IS REQUIRED

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X4.000	6061T6 Bar 1.500 X 4.00	5 ft (.5 ea)	90-Start up Operation	EM126075 = 4.83

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X4.000	5	24	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D5553-1
Inspection Dwg: D5553	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50	+/-0.030	5.498	/		vern	mm L-05
1.30	+/-0.030	1.300	/		"	
R0.06	+/-0.030	0.60	/		RG	
3.100	+/-0.030	3.099	/		vern	mm L-05
1.500	+/-0.010	1.500	/			
1.300	+/-0.010	1.300	/			
0.98	+0.020/-0.000	0.993	/			
1.25	+/-0.030	1.245	/			
0.50	+/-0.030	0.495	/			
2.250	+/-0.010	2.250	/			
4.500	+/-0.010	4.500	/			
3.00	+/-0.030	3.00	/			
0.87	+/-0.030	0.865	/			
R0.50	+/-0.030	0.500	/		RG	
R0.30	+/-0.030	0.300	/		"	
0.83	+/-0.030	0.818	/		vern	mm L-05
3.85	+0.020/-0.000	3.860	/			
0.13	+/-0.030	0.128	/			
45°	0.5°	45°	/		angle	
Ø0.257	+0.006/-0.001	0.260	/		vern	mm L-05
Ø0.129	+0.005/-0.001	0.129	/			
Ø0.377	+0.002/-0.000	0.378	/			
0.870	+0.010/-0.000	0.871	/			
30°	0.5°	30°	/		angle	
0.38	+/-0.030	0.38	/		vern	mm L-05
R0.06	+/-0.030	0.060	/		RG	

Measured by:	<i>mm</i>	Checked by:	<i>BA</i>	QC Inspector:	
Date:	<i>18/10/20</i>	Date:	<i>18-10-20</i>	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	18.10.02	New Issue	MG <i>mm</i>	<i>M</i>



Container No: S119977



Part: D5553-1

Job No: 183905

Serial No/Batch: S119977

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/21/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041414**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041414

PO Date: 10/22/18

Due Date: 11/16/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Attention: Lalonde, Marc-Andre

Via: Ground

Pynt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181763	RB23007615-3	#56 Drill Bit -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/16/18	8 pcs	0 pcs	8 pcs	\$2.80/pcs	\$22.40
2	181764	RB23007615-5	#52 Drill Bit -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/16/18	8 pcs	0 pcs	8 pcs	\$2.80/pcs	\$22.40
3	178447	RB23007615-7	#27 Drill Bit -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/16/18	8 pcs	0 pcs	8 pcs	\$2.10/pcs	\$16.80



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PURCHASE ORDER **PO041414**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	81765	RB23007615-9	#22 Drill Bit -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/16/18	12 pcs	0 pcs	12 pcs	\$2.10/pcs	\$25.20
							12 X	OCT 31 2018			
5	181760	RB23007615-11	#12 Drill Bit -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/16/18	12 pcs	0 pcs	12 pcs	\$2.10/pcs	\$25.20
							12 X	OCT 31 2018			
6	184106	RBD29904	Hoist Adapter "D" Model -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625 TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$8.40/pcs	\$8.40
7	182746	D5631-1	Spacer : Various STC's Issue P/O to ATG: ANODIZE COLOR BLACK, PER MIL-A-8625 TYPE 2 CLASS 2 PRIME AS PER MIL-PRF-23377, QSI005 4.2.1.3.2 Certification of Conformity is required	Firmed	-	11/16/18	20 pcs	0 pcs	20 pcs	\$1.85/pcs	\$37.00
							20 X	NOV 01 2018			



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PURCHASE ORDER **PO041414**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	182772	D5573-1	Base Bracket, Upper, Cable Cutter, LH : Various STC's Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 2 CLASS 2 PRIME AS PER IAW MIL-PRF-23377 1-2 MIL MAX AS PER DWG NOTE 2 C OF C IS REQUIRED	Firmed	-	11/16/18	4 pcs	0 pcs	4 pcs	\$9.40/pcs	\$37.60
9	182773	D5573-2	Base Bracket, Upper, Cable Cutter, RH : Various STC's Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 2 CLASS 2 PRIME AS PER IAW MIL-PRF-23377 1-2 MIL MAX AS PER DWG NOTE 2 C OF C IS REQUIRED	Firmed	-	11/16/18	4 pcs	0 pcs	4 pcs	\$9.40/pcs	\$37.60
10	179161	646.3810	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760- 4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	11/16/18	16 pcs	0 pcs	16 pcs	\$7.15/pcs	\$114.40



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PURCHASE ORDER **PO041414**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
11	184738	646.3812	Gusset Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760- 4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	11/16/18	140 pcs	0 pcs	140 pcs	\$6.70/pcs	\$938.00
12	183905	D5553-1	Bracket Various STC's ISSUE P/O: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 C OF C IS REQUIRED	Firmed	-	11/16/18	10 pcs	0 pcs	10 pcs	\$5.80/pcs	\$58.00
Grand Total:											\$1,343.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916411

Date: 02-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
14 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23965	Rev: N/C	
		PO: PO041414	Line: 1
10 ea	Part: D5553-1 Bracket Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Job: 23966	Rev: A	
		PO: PO041414	Line: 12
4 ea	Part: D5573-1 Base Bracket, Upper Cable LH Hard Black Anodize per MIL-A-8625F, Type II, Class 2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Job: 23962	Rev: A	
		PO: PO041414	Line: 8
4 ea	Part: D5573-2 Base Bracket, Upper Cutter RH Hard Black Anodize per MIL-A-8625F, Type II, Class 2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Job: 23963	Rev: A	
		PO: PO041414	Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>2/4/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ Made in Canada.			

DAS
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